

ITEM #	QTY	PART #	PART TITLE
-1	1	RBW3230G00131-6F-1	PACKAGING ASSY
-4	1	RBW3230G00131-6F-4	LOCKING PIN, LANDING GEAR HANDLING ASSY
10	1	RB41011	DART PLACARD
11	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

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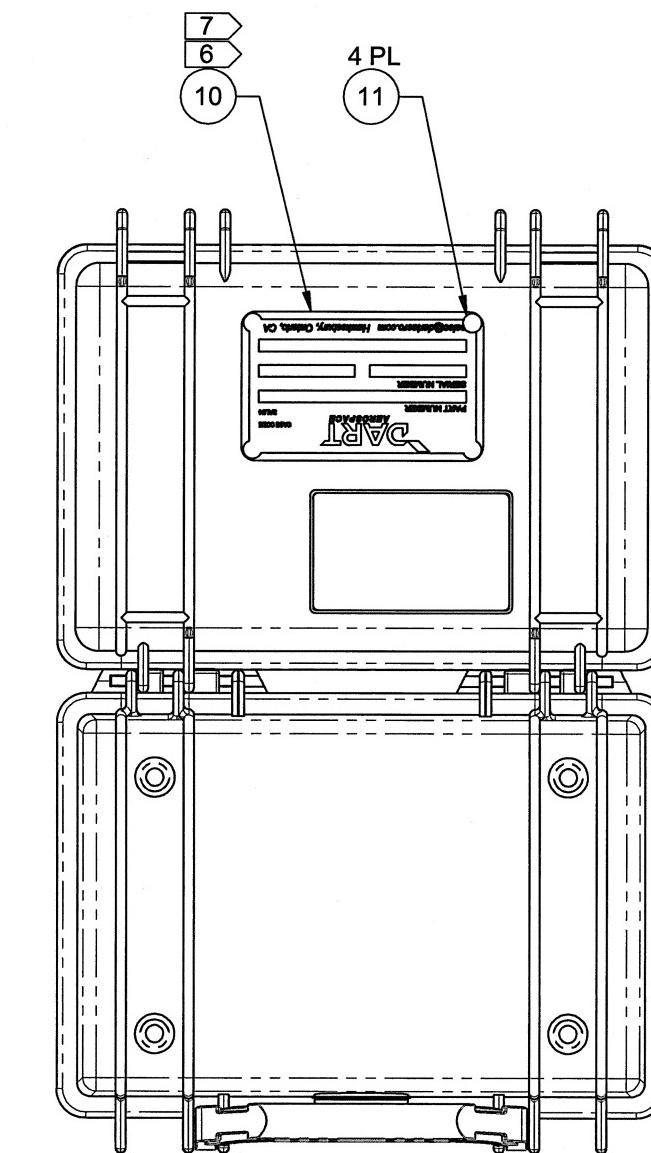
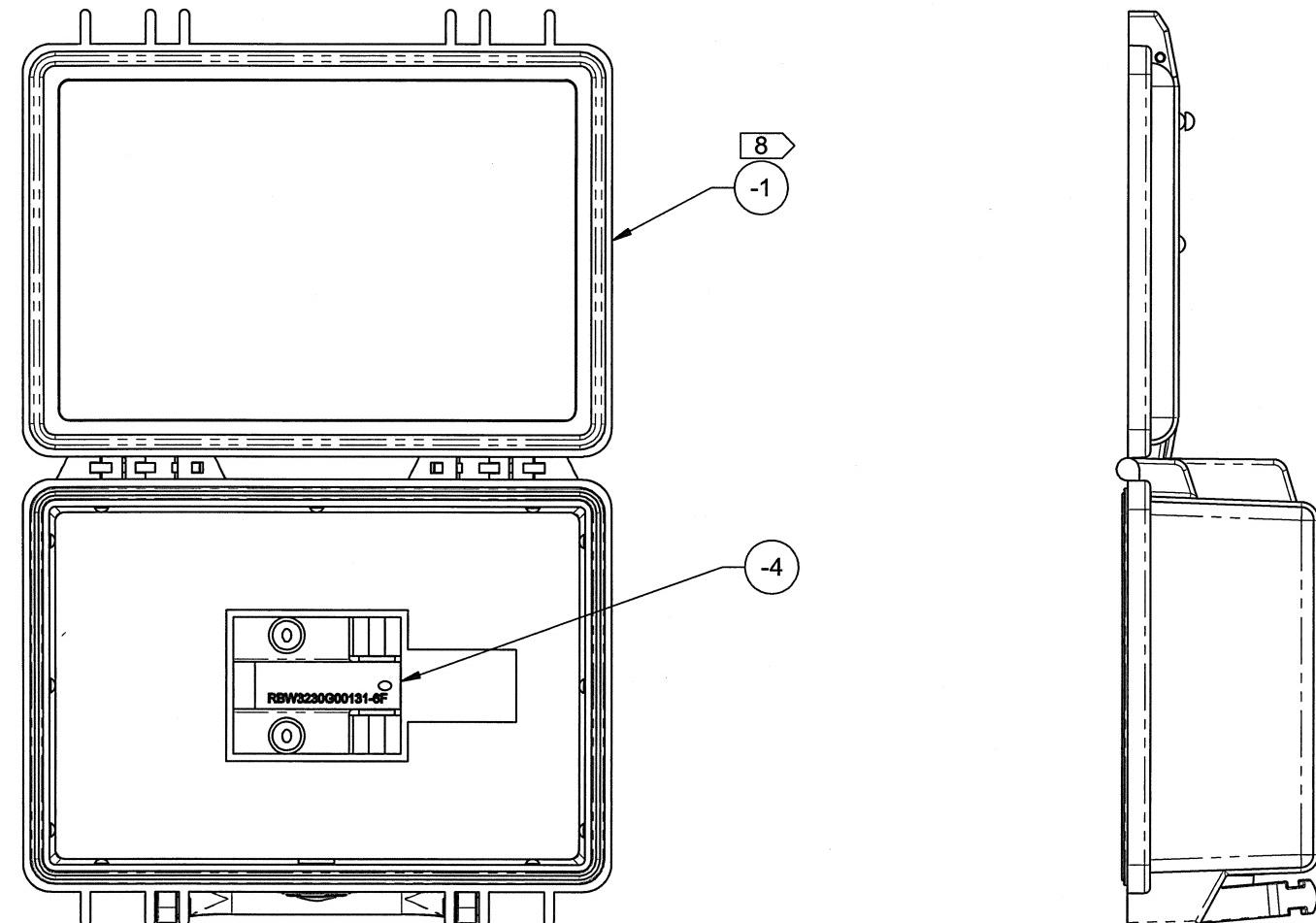
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### RBW3230G00131-6F LOCKING PIN, LANDING GEAR HANDLING

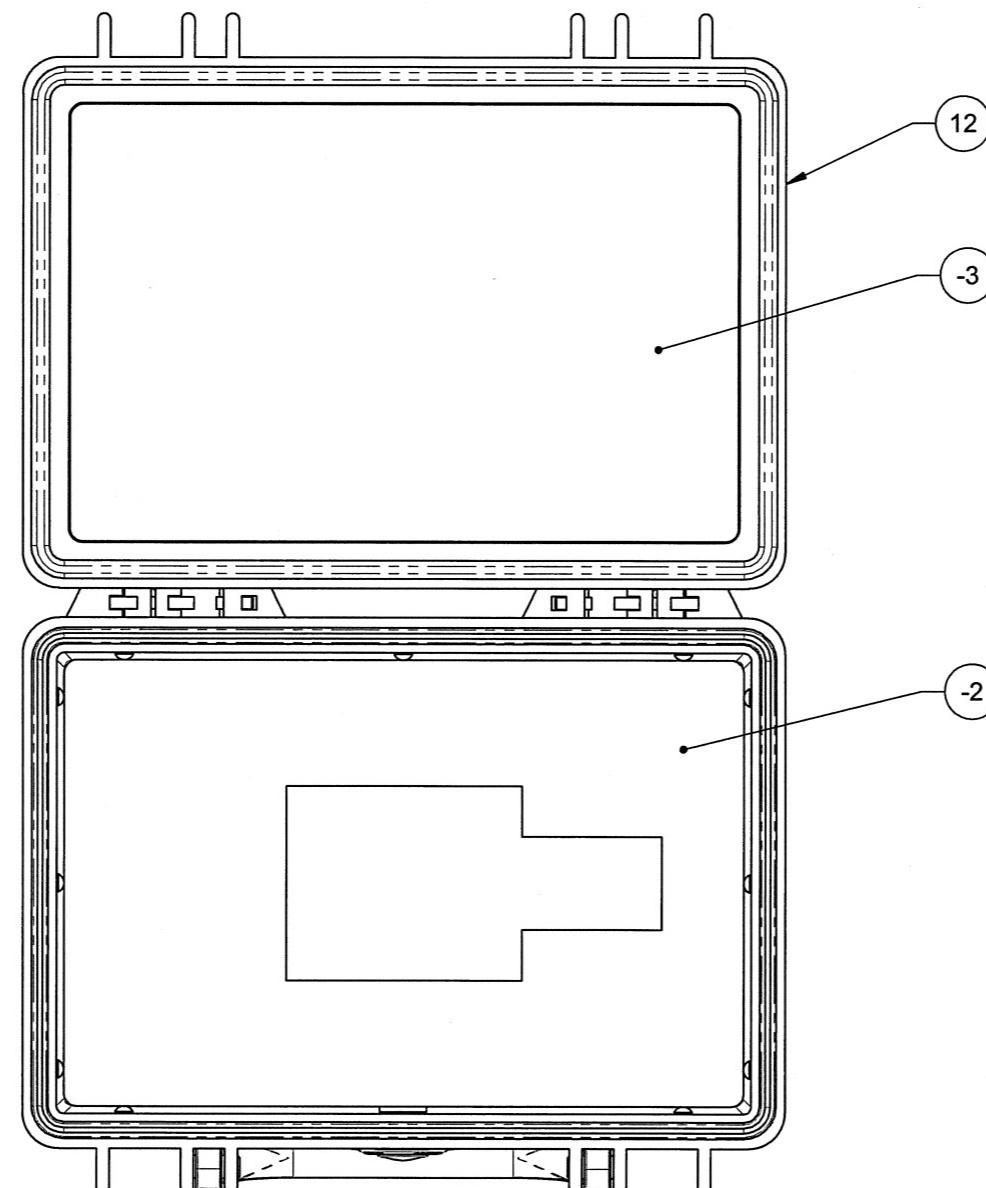
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED
- 7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 8) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	19-689	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RBW3230G00131-6F	
APPROVED	WF	REV. A	
TITLE		SHEET 1 OF 10	
LOCKING PIN, LANDING GEAR HANDLING		SCALE	NTS
DATE 4/16/2019			
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBW3230G00131-6F-2	BOTTOM FOAM
-3	1	RBW3230G00131-6F-3	TOP FOAM
12	1	PELICAN #APP-1120-E	PELICAN CASE 1120



**RBW3230G00131-6F-1 PACKAGING ASSY**

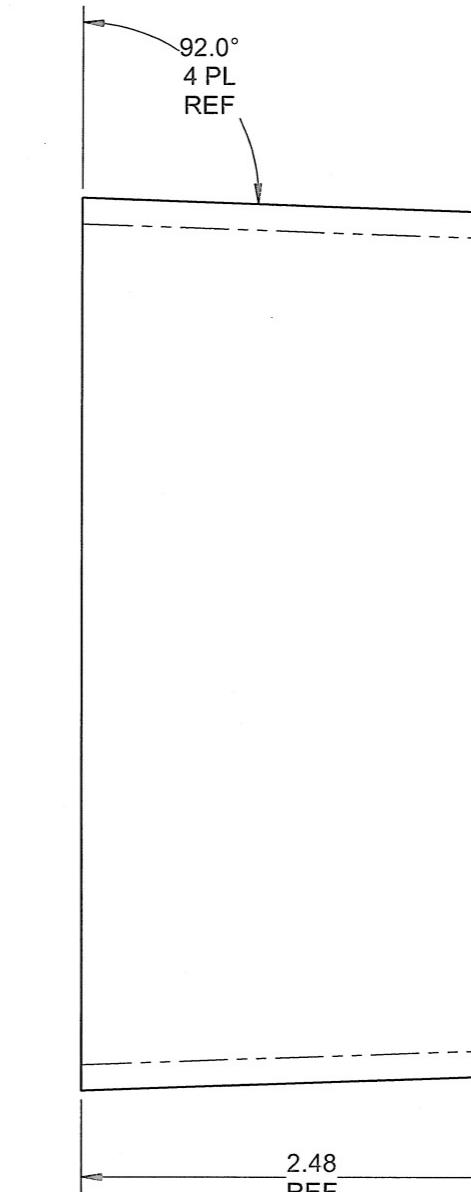
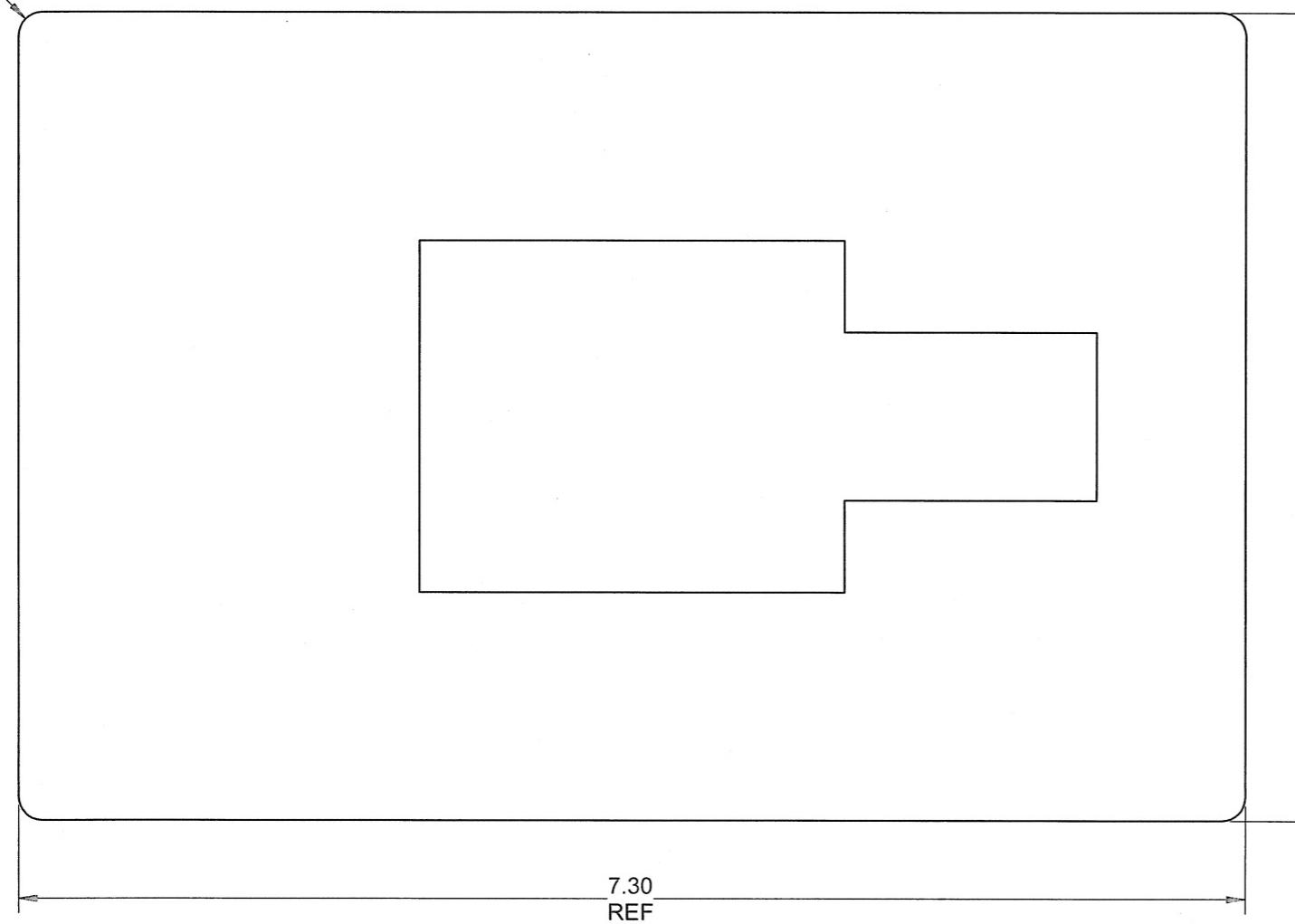
A NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW3230G00131-6F
APPROVED	WT	TITLE
		LOCKING PIN, LANDING GEAR HANDLING
DATE 4/16/2019		SCALE NTS
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REF

### RBW3230G00131-6F-2 BOTTOM FOAM

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#### NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220 REF
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW3230G00131-6F-2 REV. A.STEP

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW3230G00131-6F
APPROVED	WJ	REV. A
DATE 4/16/2019		SHEET 3 OF 10
TITLE		SCALE
LOCKING PIN, LANDING GEAR HANDLING		NTS
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4 PL  
REF

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### RBW3230G00131-6F-3 TOP FOAM

#### NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220 REF
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW3230G00131-6F-3 REV. A.STEP

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW3230G00131-6F
APPROVED	WF	TITLE
		LOCKING PIN, LANDING GEAR HANDLING
DATE	4/16/2019	SCALE
		NTS
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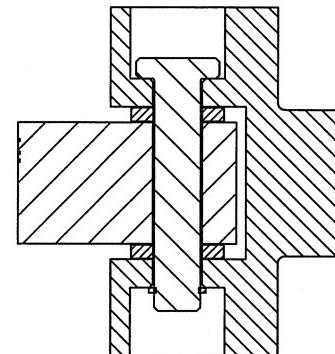
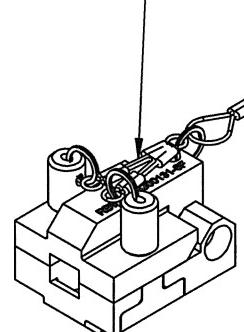
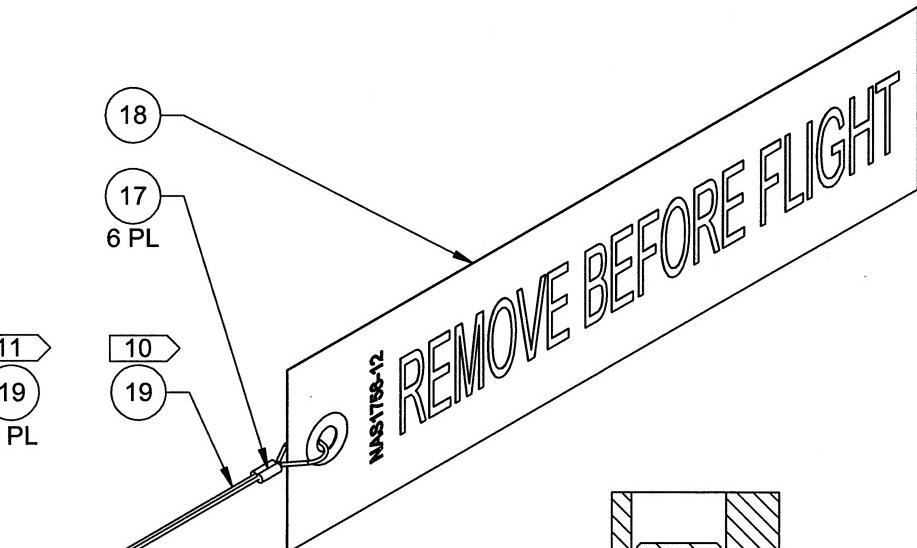
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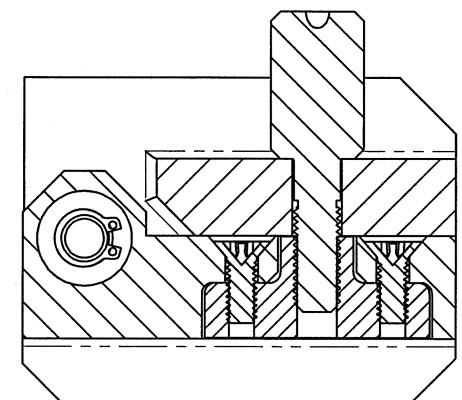
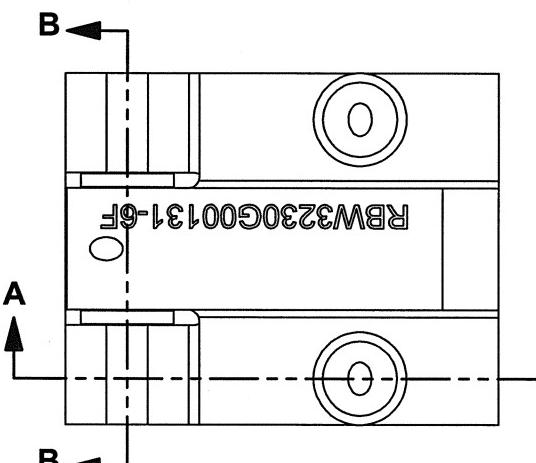
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ITEM #	QTY.	PART #	PART TITLE
-5	1	RBW3230G00131-6F-5	TOP LANDING GEAR HANDLING
-6	1	RBW3230G00131-6F-6	BOTTOM LANDING GEAR HANDLING
-7	2	RBW3230G00131-6F-7	BLOCK
-8	2	RBW3230G00131-6F-8	THREADED PIN
-9	1	RBW3230G00131-6F-9	PIVOT PIN
13	2	McMaster#92150A124 OR EQUIV	NYLON FLAT WASHER FOR 1/4" SCREW SIZE
14	1	McMaster#98410A113 OR EQUIV	STEEL ZINC YELLOW PLATED EXTERNAL RETAINING RING FOR 1/4" OD.
15	4	McMaster#90273A193 OR EQUIV	STEEL ZINC PLATED PHILLIPS FLAT HEAD SCREW 82° COUNTERSINK #8-32 X 7/16" LG.
16	3	McMaster#90177A213 OR EQUIV	ZINC PLATED STEEL SPLIT RING 9/16" OD x 7/16" ID. x 1/16" THK
17	6	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
18	1	NAS1756-12	REMOVE BEFORE FLIGHT FLAG
19	AR	CARR LANE #CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.



**SECTION B-B**



**SECTION A-A**

**NOTES:**  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A

3) FINISH: N/A  
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
                   X.XX = +/- 0.01" / +/- 0.5°  
                   X.XXX = +/- 0.005" / +/- 0.1°  
                   X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS  
6) IDENTIFICATION: N/A

6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN

**7) ASSEMBLE AS SHOWN  
8) APPLY RED THREADLOCK**

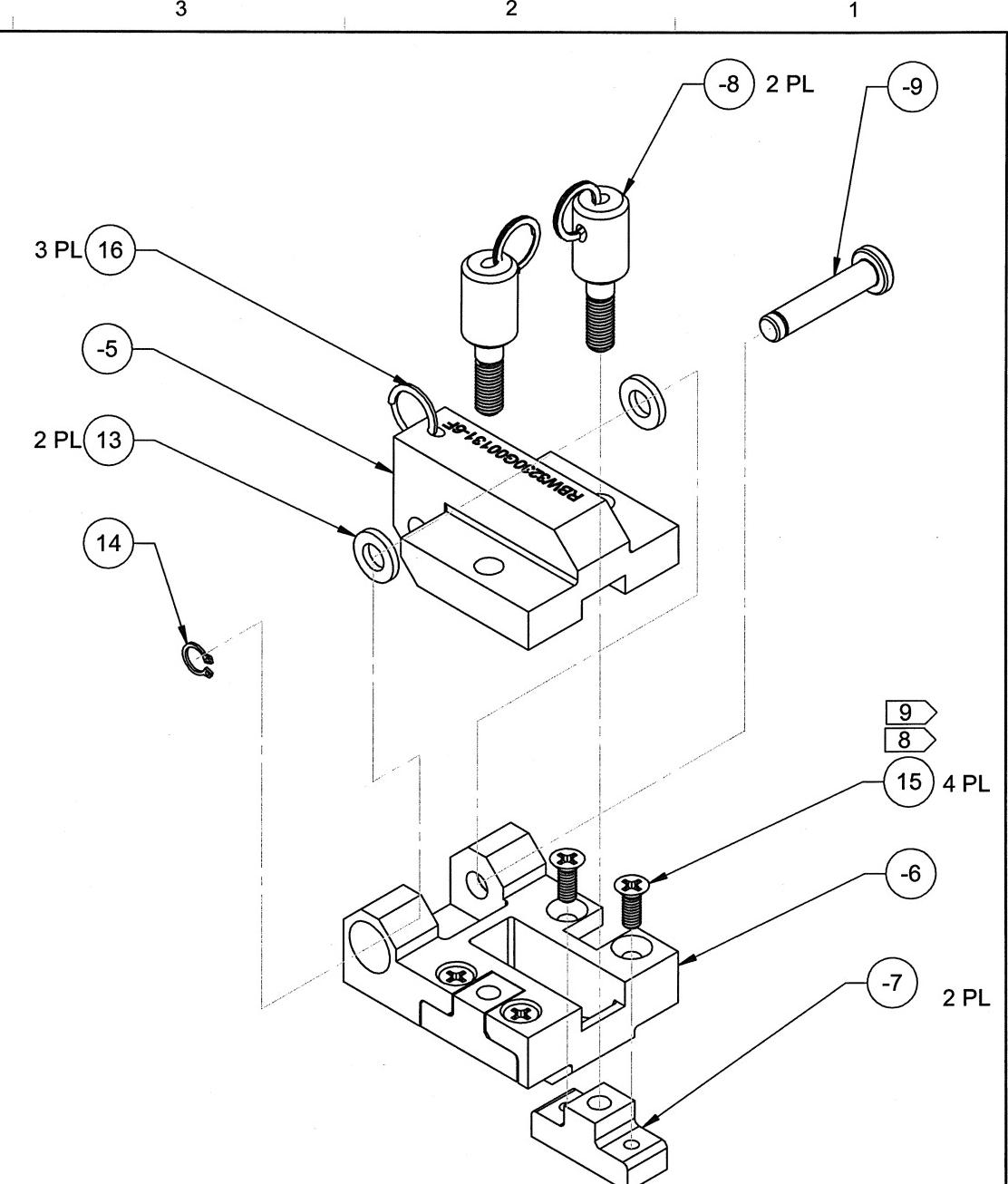
8) APPLY RED THREADLOCKER LOCITE 263/262 ON THREADS OF ITEMS 15 THEN ASSEMBLE WITH ITEMS -7 AND REMOVE EXCESS  
9) INSTALL ITEMS 15 HAND TIGHT

9) INSTALL ITEMS 15 HAND TIGHT  
10) ASSEMBLED LANYARD LENGTH

10) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREE!!  
11) ASSEMBLED LANYARD LENGTH MUST BE 4" +/- 1", LANYARD MUST MOVE FREE!!

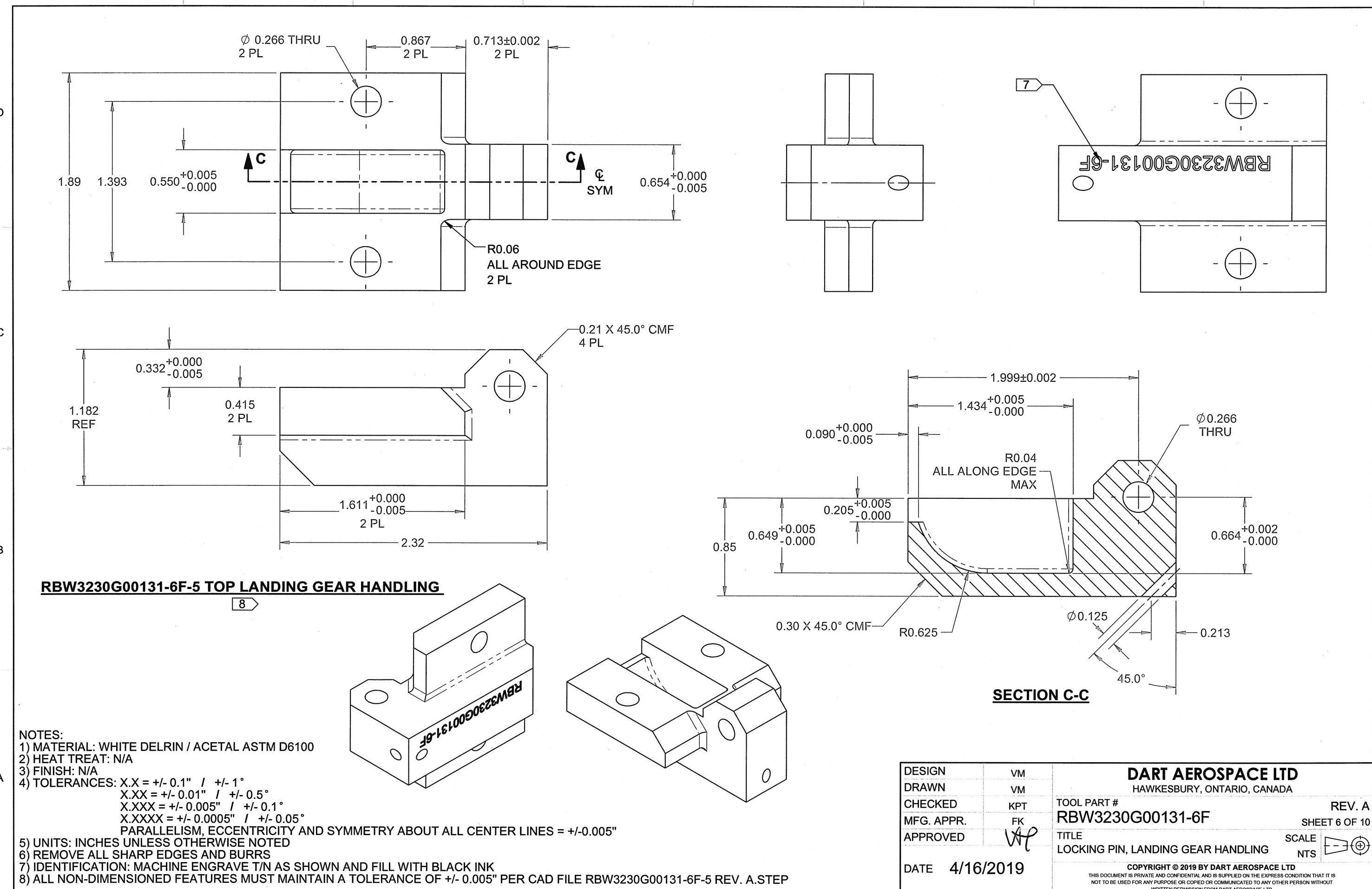
11) ASSEMBLED LANYARD LENGTH MUST BE 4" +/- 1", LANYARD MUST MOVE FREELY  
12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT PAK INTO A TIGHT FITTING

12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



## **RBW3230G00131-6F-4 LOCKING PIN, LANDING GEAR HANDLING ASSY**

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	SHEET 5 OF 10
MFG. APPR.	FK		
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	4/16/2019	LOCKING PIN, LANDING GEAR HANDLING	NTS
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**NOTES:**  
1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100  
2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X

#### IV) VOLUNTEERS

$$\Delta \text{XXX} = \pm/0.005'' / \pm/0.1$$

$$X_{XXXX} = \pm/0.0005'' / \pm/0.0$$

X.XXXX - 17-0005 PARALLELISM ECCEN

PARALLELISM, ECCENTRICH  
5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS

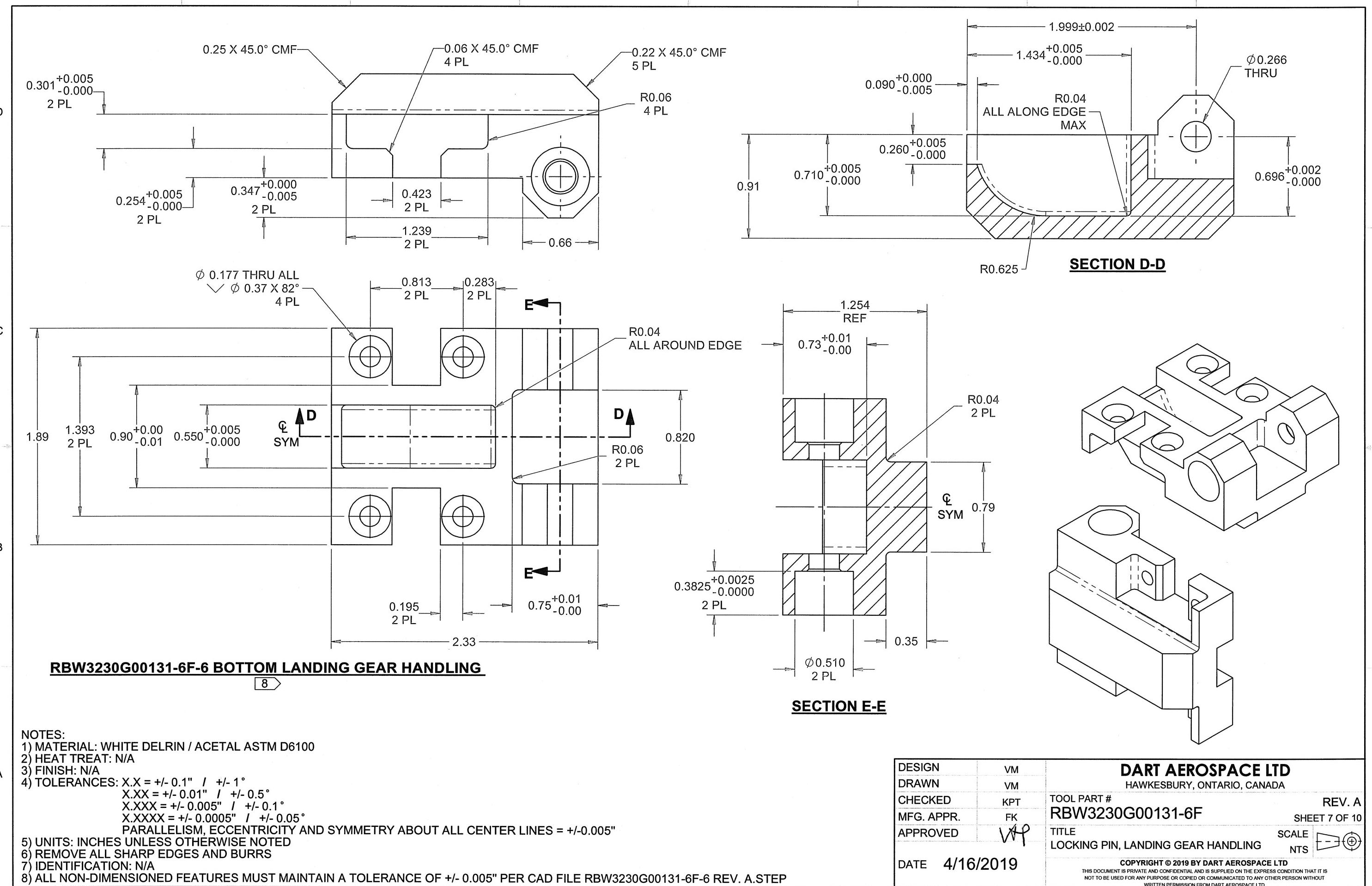
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: MACHINE ENGRAVE T/N

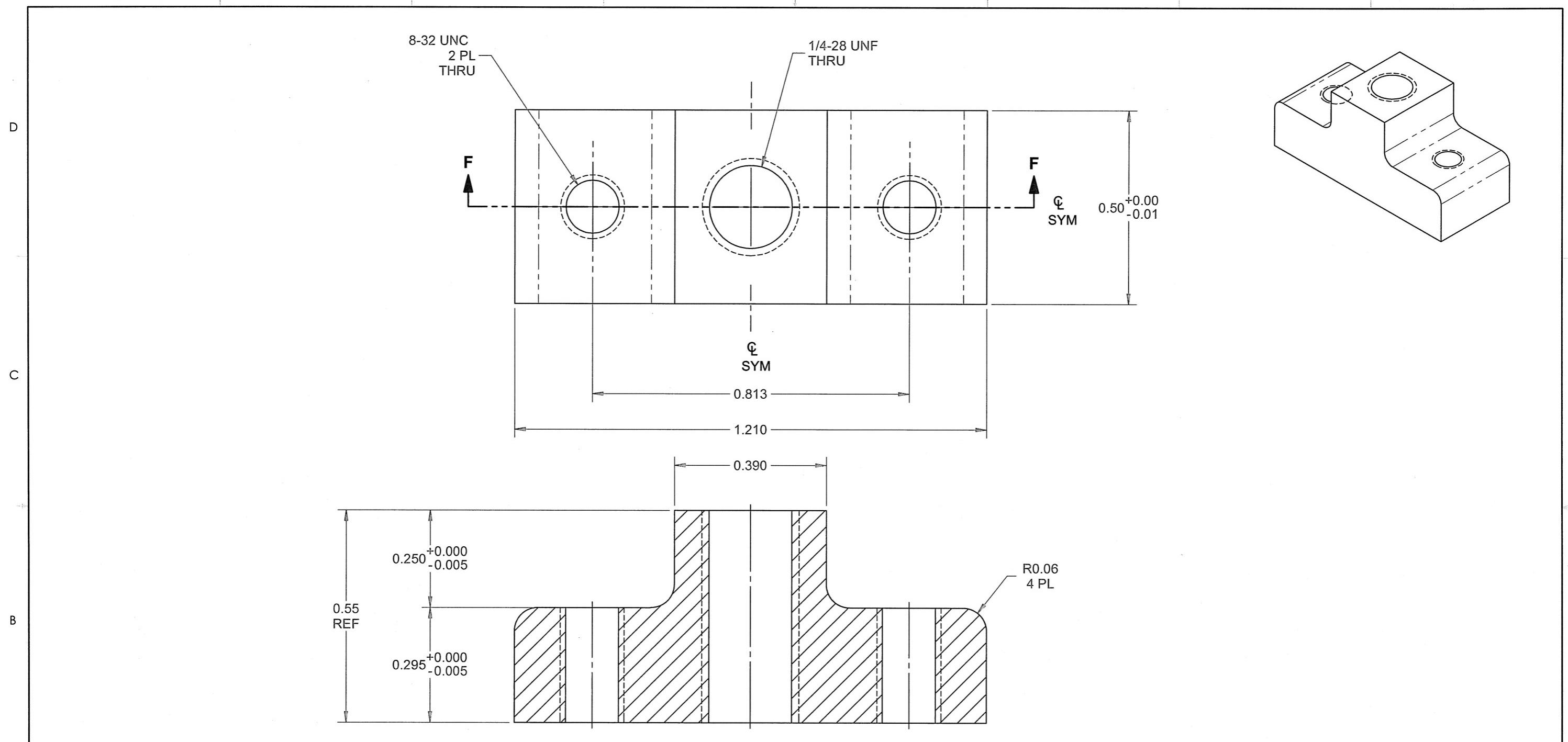
7) IDENTIFICATION: MACHINE ENGRAVE I/N  
8) ALL NON DIMENSIONED FEATURES MUST

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RBW3230G00131-6F	
APPROVED	VAP	REV. A	
DATE	4/16/2019	SHEET 6 OF 10	
		TITLE	SCALE
		LOCKING PIN, LANDING GEAR HANDLING	NTS
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**NOTES:**

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

**RBW3230G00131-6F-7 BLOCK**

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW3230G00131-6F
APPROVED	W	REV. A
		SHEET 8 OF 10
		SCALE
		NTS
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DATE 4/16/2019

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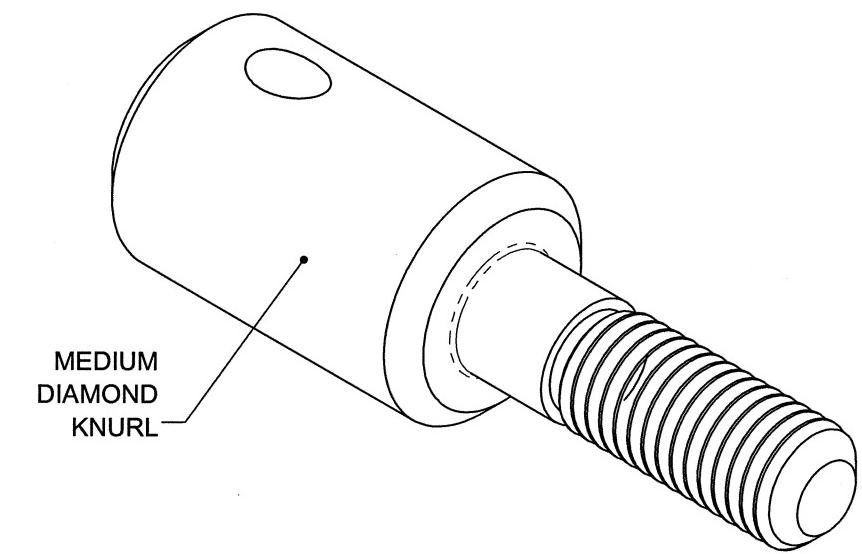
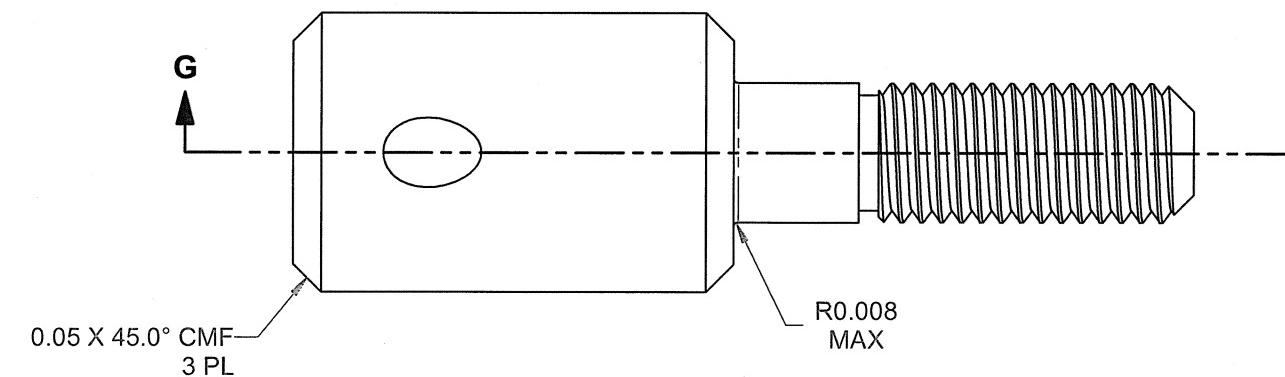
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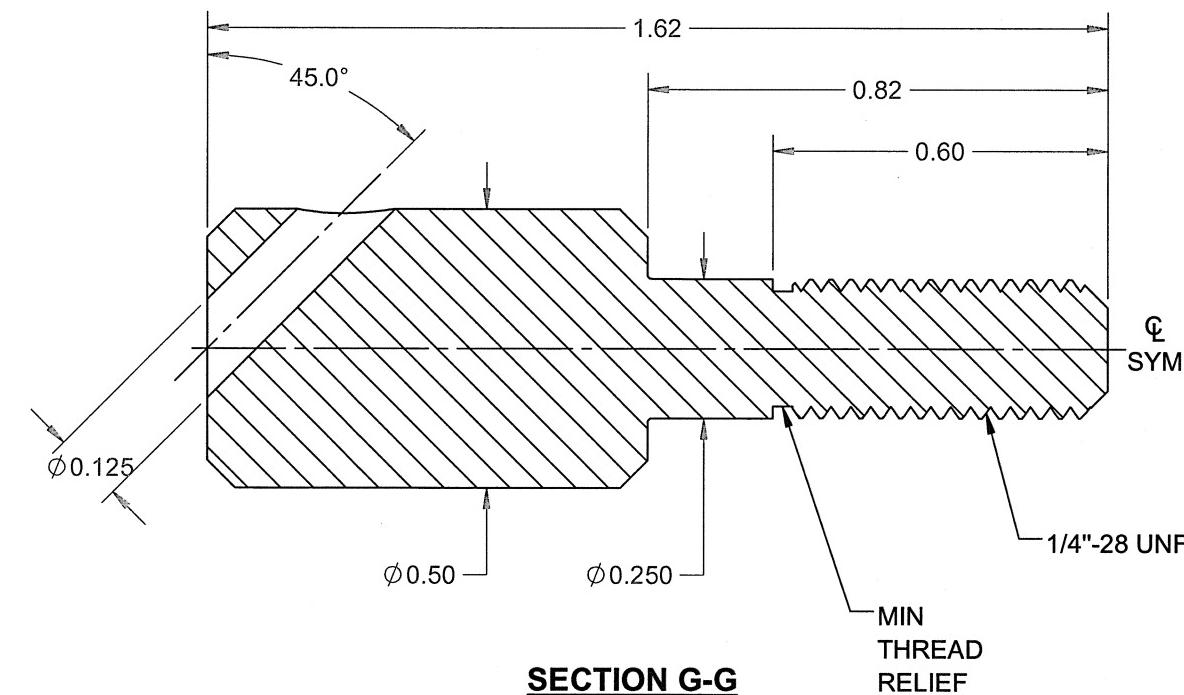
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### RBW3230G00131-6F-8 THREADED PIN

#### NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 $X.XX = +/- 0.01" / +/- 0.5°$   
 $X.XXX = +/- 0.005" / +/- 0.1°$   
 $X.XXXX = +/- 0.0005" / +/- 0.05°$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW3230G00131-6F
APPROVED	WT	REV. A SHEET 9 OF 10 TITLE SCALE NTS LOCKING PIN, LANDING GEAR HANDLING
DATE	4/16/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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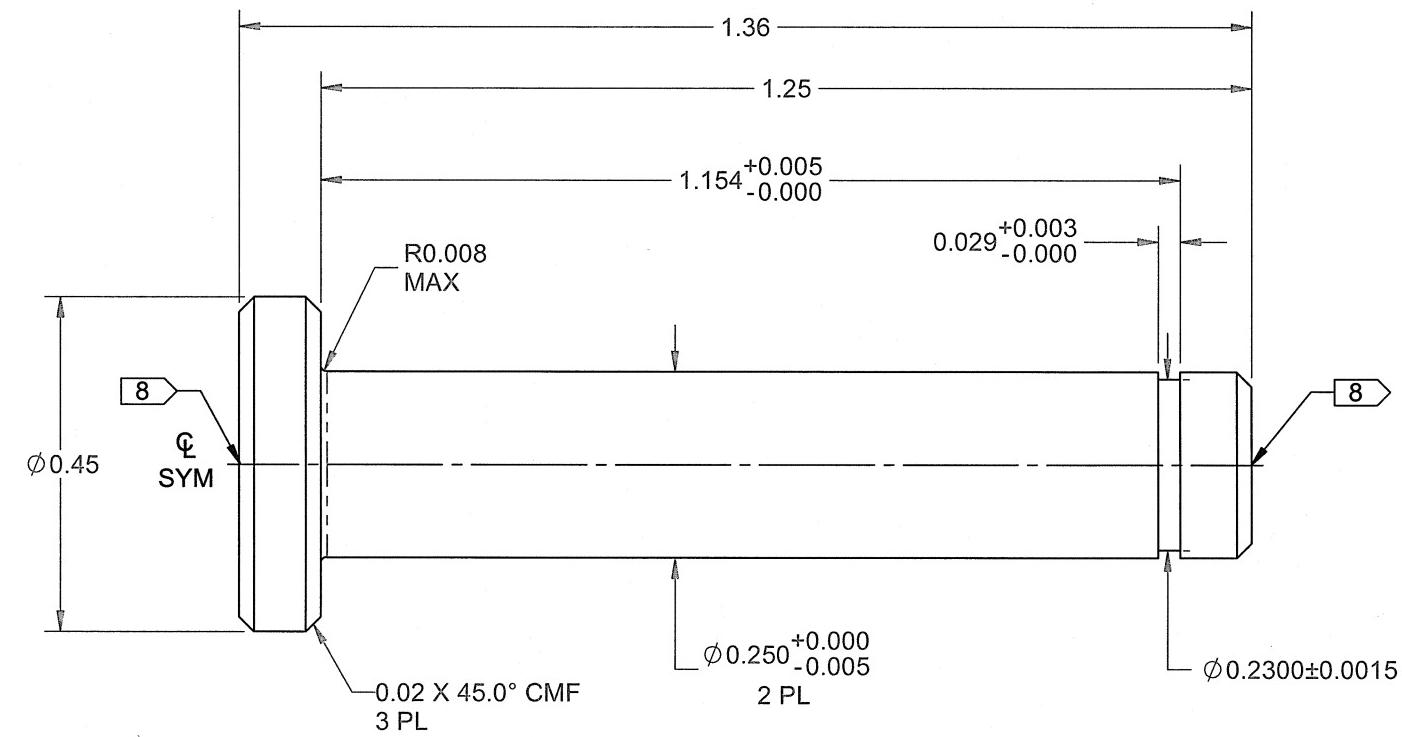
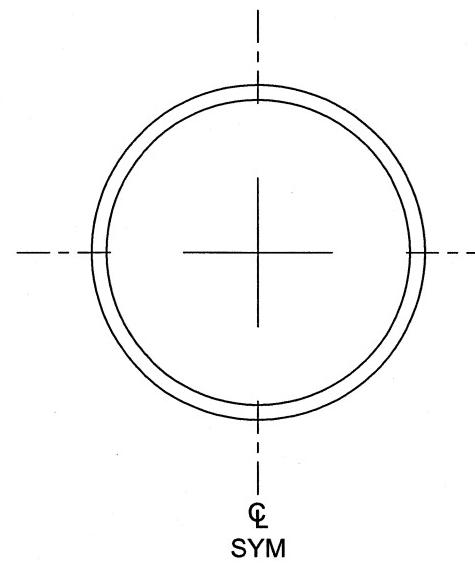
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### RBW3230G00131-6F-9 PIVOT PIN

#### NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES, BURRS, AND WELD SPATTERS IF APPLICABLE
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW3230G00131-6F
APPROVED	WJ	REV. A SHEET 10 OF 10
DATE 4/16/2019		TITLE LOCKING PIN, LANDING GEAR HANDLING SCALE NTS
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